	er ID 60670 , 2010 8:50:10 AM								•		Page 1
Revision ID: Item Name:	D3826-041  Rib / Gusset Assembly  7/19/2010 Start Qty: 6.00  7/23/2010 Req'd Qty: 6.00		Accept	Cust Item I				Setup	Start Stop		
Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop		110 110 110 110 1 110 110 110 110 1
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						****	***	,		
D3826	Rev B	·							1		•
100 Large Fab	Large Fab		0.00	,				(p	//	.07.0	3
Large Fab	1- use D rib and v Batch: <u> </u>	T9434 to assemble D2325 supweld as per dwg D3826ロ A/	pport gusset together□2-	locate D2325 on							
	QC9- Inspect visual p	per QSI004- Fusion Welds	0.00					PDI	0.07	260	i
QC Quality Control	Мето		0.00						<u> </u>	, <u>, , , , , , , , , , , , , , , , , , </u>	<del></del>
	•			•							•
120	QC5- Inspect part con	mpleteness to step on W/O	0.00	0/4/76		į	(46				
QC Quality Control	Memo		0.00	(3, 1,06		•		シノ	: - '	* · · · · · · · · · · · · · · · · · · ·	·

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W/O:			WO	RK ORDER CHANG	GEŜ	1			
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQA</b>		Date: _	
	Re	esolution:	Disposition	ı:	QA: N/C C	losed:	<u> </u>	Date: _	
NCR:		•	WORK ORDE	R NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Se Action Description	ction B	Verifica		Approval	Approval
1.71.11	:	Section A	Chief Eng	Chief Eng	Date	Sectio		Chief Eng	QC Inspector
							<u> </u>		

## Work Order ID 60670

Monday, July 19, 2010 8:50:10 AM



Page 2

Item ID:

D3826-041

Accept

Setup Start

**Revision ID:** 

Item Name: Rib / Gusset Assembly

**Start Date:** 

7/19/2010

Start Qty: 6.00

Required Date: 7/23/2010 **Req'd Qty:** 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_ Date:

Tooling:

Date:

Run

Start

Qty

Stop

Stop



QC: \_\_\_\_ Date:\_\_\_\_\_

SPC (Y/N):

Tool ID

Date:

Tool # Plan

Code

Accept Qty

Reject Reject

Insp. Number Stamp

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

**Run Hours** 0.00

0.00

Set Up/

10-07-26

140

QC Quality Control QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

10/07/269J 10/07/269J

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W/O:			V	ORK ORDER CHANGE	S					1
DATE	STEP	PROCI	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*								
- 4									. 1	
Part No:		PAR #:	Fault Ca	tegory:	NCI	R: Yes N	o <b>DQ</b> A		_ Date: _	
	R	Resolution:	Disposit	ion:	QA	: N/C Clos	sed:	<u> </u>	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE	(NCR)				
DATE *	STEP	Description of NC		Corrective Action Section	n B		Verifica	tion	Approval	Approval
טאור <sub>פּ</sub>	SILP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector
		i i				*				
					<b>.</b>					
	4									

## **Picklist Print**

Monday, July 19, 2010 8:50:13 AM

Work Order ID: 60670

Parent Item:

D3826-041

Parent Item Name:

Comments:

Rib / Gusset Assembly

IPP Rev:A 08-12-01 new issue DD verified by:EC

Manufactured

Manufactured

No

No



60274

Start Date: 7/19/2010

Required Date: 7/23/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1  Basket Rib		Manufactured	No				Each-	14.0000	1 	6	Cpl.	10.07	22
		*.		<u>Location</u> WA	59925	Loc	<u>Otv</u> 14 4	Loc Code	_	-[4	)		

D3929-041

Gusset Assembly

<u>Location</u>	Loc Qty	Loc Code
WA .	11	
59927	5	
60327	6	
	Each	6.0000

10

Each

11.0000



Gusset Assembly

 Loc Qty
 Loc Code

 WA
 6

 59979
 ♠ 6

(5) 6

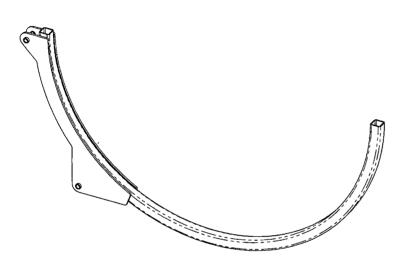
(pl10.07.22

Dart Ae	rospace l	_td							<b>5</b>
W/O:			WC	ORK ORDER CHANGES	SES				
DATE	STEP	PRO	OCEDURE CHA	NGE .	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								į	
Part No	:	PAR #:	Fault Cate	gory:N	CR: Yes	No <b>DQ</b>		Date: _	
	Res	solution:	Dispositio	n: Q	A: N/C Cld	osed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMANC	E (NCR	)			
		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign &	Section		Chief Eng	QC Inspector

NCR:		,	WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section E	<u> </u>	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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	·				į.			
					_			

QTY. ITEM P/N DESCRIPTION Х D3826-041 RIB/GUSSET ASSY D2235-1 11 12 D3929-041 GUSSET ASSEMBLY D3929-042 GUSSET ASSEMBLY

4



D3826-041 RIB/GUSSET ASSY

SHOP COPY RETURNLIO. ENGINEERING UNCONTROLL SD CORY SUBJECT TO AMENDMENT WITHOUT NUTICE

В	D3929-I UPDAT	041/-042 WER ED WEIGHT (	RE D2325 (ZN D3-1 & ZN D6-2); ZN A8-1). REASON: SEE NCR#09-042.	(#09-042. MB 09.04.16				
Α	NEWIS	SUE		МВ	08.09.23			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	13	DART AEROSPA	CEL	TD			
DRAW	N	3	HAWKESBURY, ONTARI					
CHECK	ŒD	PE	DRAWING NO.		REV. B			
MFG. A	PPR.	W	D3826		SHEET 1 OF 2			
APPRO	VED	LMP	TITLE		SCALE			
DE APP	PR.	4	RIB/GUSSET ASSY		NTS			
DATE	09.0	4.16	1 COPYRIGHT © 2008 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIES NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATION OF THE PRIVATE AND THE PRIVATE AND THE PRIVATE AND THE PRIVATE AND THE PRIVA	ON THE EXPRES	S CONDITION THAT IT IS			

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION:N/A
7) WEIGHT: 3.32 lbs

5

Dart Ae	rospace	e Ltd								, , ·
W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	NCI	R: Yes N	lo <b>DQA</b>		_ Date: _	<u></u>
	R	esolution:	Disposition	on:	QA	N/C Clo	sed:		Date: _	
NCR:		V	WORK ORE	ER NON-CONFOR	MANCE	(NCR)				
DATE	CTED	Description of NC		-,	Section B		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section		Chief Eng	QC Inspector
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								1		
								1		,
								<b>I</b>		

3 \* GUSSET ASSEMBLY D D3929-041 GUSSET ASSEMBLY w/o 40610 0.250 -D3826-041 RIB/GUSSET ASSY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. B MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE RIB/GUSSET ASSY

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OF TO BY USED ON ANY PROPERTY OF LOOPE ON COMBUNITY DO NOT MORE PROPERTY ON ANY PROPERTY OF LOOPE ON COMBUNITY DO NOT MAY PROPERTY OF LOOPE ON COMBUNITY DE APPR. DATE 09.04.16

<b>Dart Aeros</b>	pace Ltd
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W/O:			V	VORK ORDER C	HANGES						
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	}				,						
Part No:		PAR #:	Fault Category: No			ICR: Yes	CR: Yes No DQA:		: Date: Date:		
,	R	tesolution:	Disposition:			QA: N/C Closed:					
NCR:			VORK OR	DER NON-CON	FORMAN	CE (NC	R)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Desc	cription	Sign		ni <mark>on</mark> n C	Approval Chief Eng	Approval QC Inspector	
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